



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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646.3301

Job Sheet 196019



Part No: 646.3301

Job Qty: 4 pcs

Part Name: Upper Cutter Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/4/19

Job Tracking No:

Due Date: 6/28/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 646.3300 REV NC3 IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.07 AS PER
DWG NC3 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	4 pcs		6/28/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		AS 19-8-25
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		



Container No: S208562



Part: 646.3301

Job No: 196019

Serial No/Batch: S208562

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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Date: 06/26/19

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					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
120	Small Fab - 2 - B4B	4 pcs	6/28/19	0.00 5.56	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	A2 19-8-25
					Small Fab - 7 - B4B	
130	QC 5	4 pcs	6/28/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	DAS 81
					QC 5 - 30	9-89
					QC 5 - 40	SEP 10 2019
140	Packaging 3-1 - Stock - B4B	4 pcs ✓	6/28/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	CCK 018
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
		</				

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Rosales, Oscar

					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
150 QC 21 - SA	4 pcs ✓	6/28/19	0.00 0.00	QC 21 - SA - 21 ✓	CCK018	
				QC 21 - SA - 70		
				QC 21 - SA - 53		

Part Op 110 - Pick Kit

Descriptions: 120 - Small Fab - TWO fastener must be install finger-tight (see note 9) Assemble as per dwg and apply loctite 598 on all faying surfaces shown on dwg per note 7. exp. date: 5173363 exp 12/20

130 - QC5- Inspect part completeness to step on W/O

140 - Identify as per dwg & Stock Location: ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

150 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
646.3310	LH Half - Upper Cutter Assembly	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	517251(2) 5202710
646.3311	RH Half - Upper Cutter Assembly	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5202297
646.3312	Center Plate	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5186703
646.3313	Upper Guide	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5191930
646.3314	Blade	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5130657(3) 5193866(1)
646.3315	Blade	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5130578(1) 5170730(1)
646.3316	Blade	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5130582
AN3-12A	Bolt	8 Ea (2 ea)	110-Packaging 1 - Pick Kit	5166926
AN3-14A	Bolt	4 Ea (1 ea)	110-Packaging 1 - Pick Kit	5112900
MS21042L08	Nut	72 Ea (18 ea)	110-Packaging 1 - Pick Kit	5193124
MS21042L3	Nut	12 Ea (3 ea)	110-Packaging 1 - Pick Kit	5092201(1) 5149299(1)
MS27039-08-19	Screw	72 Ea (18 ea)	110-Packaging 1 - Pick Kit	5006962(1) 5158309
NAS1149F0332P	Washer	24 Ea (6 ea)	110-Packaging 1 - Pick Kit	5157648(1) 5162104(1)
NAS1149FN832P	Washer	144 Ea (36 ea)	110-Packaging 1 - Pick Kit	5191300

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	646.3310	4	10	0
	646.3311	4	10	0
	646.3312	4	30	0
	646.3313	4	15	0
	646.3314	4	11	0
	646.3315	4	11	0
	646.3316	4	12	0
	AN3-12A	8	231	0
	AN3-14A	4	232	0
	MS21042L08	72	500	0
	MS21042L3	12	1,860	0
	MS27039-08-19	72	518	0
	NAS1149F0332P	24	3,221	0
	NAS1149FN832P	144	1,620	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				MRB (QS1042)																															
Date : _____		Sequence #: _____		QTY Affected : _____		Disposition																																	
Description Work Order Deviation						Completed By																																	
						Lead hand / Supervisor																																	
						QC / QA Coordinator																																	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐						FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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